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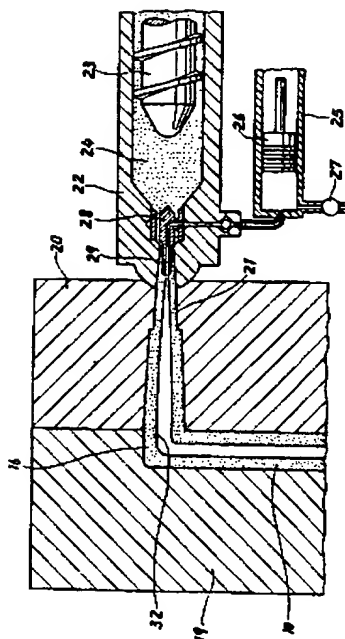
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TITLE : FORMING OF ENCLOSURE IN
TELEVISION RECEIVER



ABSTRACT : PURPOSE: To obtain a strong structure by applying effectively secondary pressure by forming a bezel one-body type cabinet by using a thimbleless formation, and also, injecting high pressure gas to at least a holding part of a CRT.

CONSTITUTION: A bezel integrated cabinet 10 is formed by a dies 19, 20 by using a thimbleless forming method. From an injection cylinder 22, a molten resin 24 is injected to a cavity of the dies 19, 20 through a gate 21, and subsequently, a little later, gas in a gas press-in cylinder 25 is compressed by a piston 26, and this gas is injected into a cavity through a torpedo 28 and a gas injection port 29. As for the cabinet 10 which is formed in such a manner, especially to a wall thickness part 16 of its corner, secondary pressure is applied by gas, therefore, not only a piping defect can be prevented but also a thick stop boss can be formed by gas pressure. In such a manner, only a holding part of a CRT can be formed to a storing structure by a short forming cycle, and also, by the plate thickness of the same degree as that of a regular formed part.

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